

Date: Monday, 02/02/2009 11:50:08 AM  
User: Julie Dawson

## **Process Sheet**

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	HI-STEP LEG ASSEMBLY								
Job Number	45395										
Estimate Number	10385										
P.O. Number	:	Part Number	: D3065041								
This Issue	: 02/02/2009	S.O. No.	: D3065 REV B								
Prsht Rev.	: NC	Project Number	: N/A								
First Issue	: / /	Drawing Revision	: B								
Previous Run	: 44395	Material	:								
Written By	:	Due Date	: 15/02/2009								
Checked & Approved By	: <u>SDU 09-02-09</u>	Qty:	60								
Comment	Est Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RF										
<b>Additional Product</b>											
Job Number:											
Seq. #:	Machine Or Operation:	Description :									
1.0	45395A	STEP SPACER									
Comment: Sub-Component STEP SPACER 1 x D3065-1 Batch <u>B43858</u> <u>33x</u> <u>344395</u> <u>Ep09/03/19</u>											
2.0	45395B	STEP SPACER									
Comment: Sub-Component STEP SPACER 1 x D3065-3 Batch <u>B44395</u> <u>55x</u> <u>345395</u> <u>Ep09/03/19</u>											
3.0	45395C	STEP LEG									
Comment: Sub-Component STEP LEG 2 x D3065-5 Batch <u>B44395</u> <u>22x</u> <u>345395</u> <u>Ep09/03/19</u>											
4.0	45395D	STEP SPACER									
Comment: Sub-Component STEP SPACER 1 x D3065-7 Batch <u>B43858</u> <u>44x</u> <u>342344</u> <u>Ep09/03/19</u>											
5.0	MS20470AD44	Rivet, Universal Head									
Comment: Qty.: 30.0000 Each(s)/Unit Total : 1800.0000 Each(s) Rivet, Universal Head Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>30</td> <td>MS20470AD4-4</td> <td>Rivet</td> <td><u>1110427</u></td> </tr> </tbody> </table> <u>Ep09/03/19</u>				Qty	Part Number	Description	Batch	30	MS20470AD4-4	Rivet	<u>1110427</u>
Qty	Part Number	Description	Batch								
30	MS20470AD4-4	Rivet	<u>1110427</u>								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng.	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/02/2009 11:50:08 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 45395

Part Number: D3065041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3065 and Identify as D3065-041

EF 09/03/09 (60)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SR 09/03/09 (60)

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

counted

SD 09-03-23 (60)

9.0 QC21 FINAL INSPECTION/W/O RELEASE



09/03/24 (J)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-03-23

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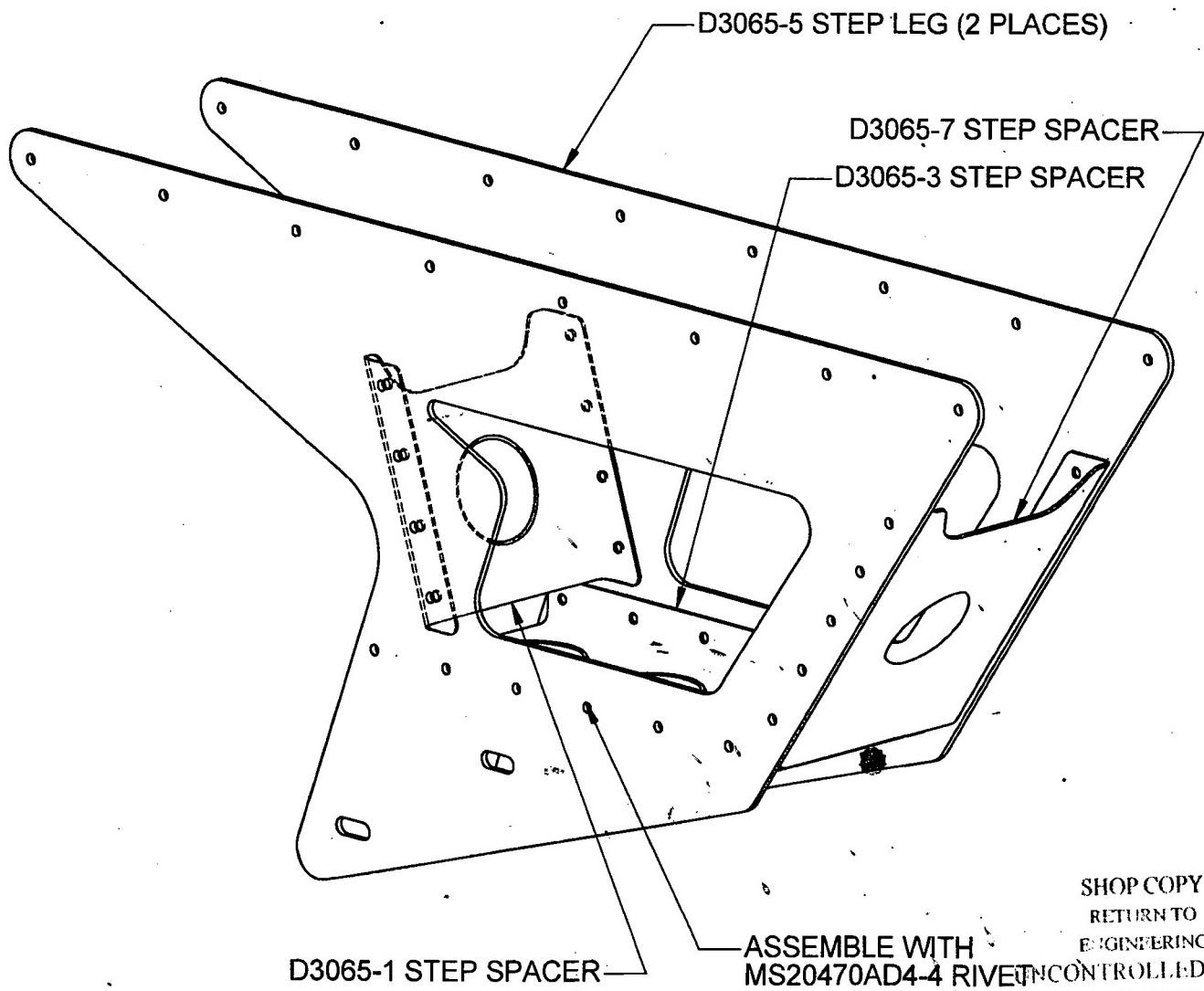
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. <b>D3065</b>	REV. B	SHEET 1 OF 5
DATE <b>06.05.23</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:2	
A	02.09.11	NEW ISSUE		
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5		

**RELEASED***06.06.20 MM*

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WORK ORDER

NO. *W5395***D3065-041 STEP LEG ASSEMBLY**

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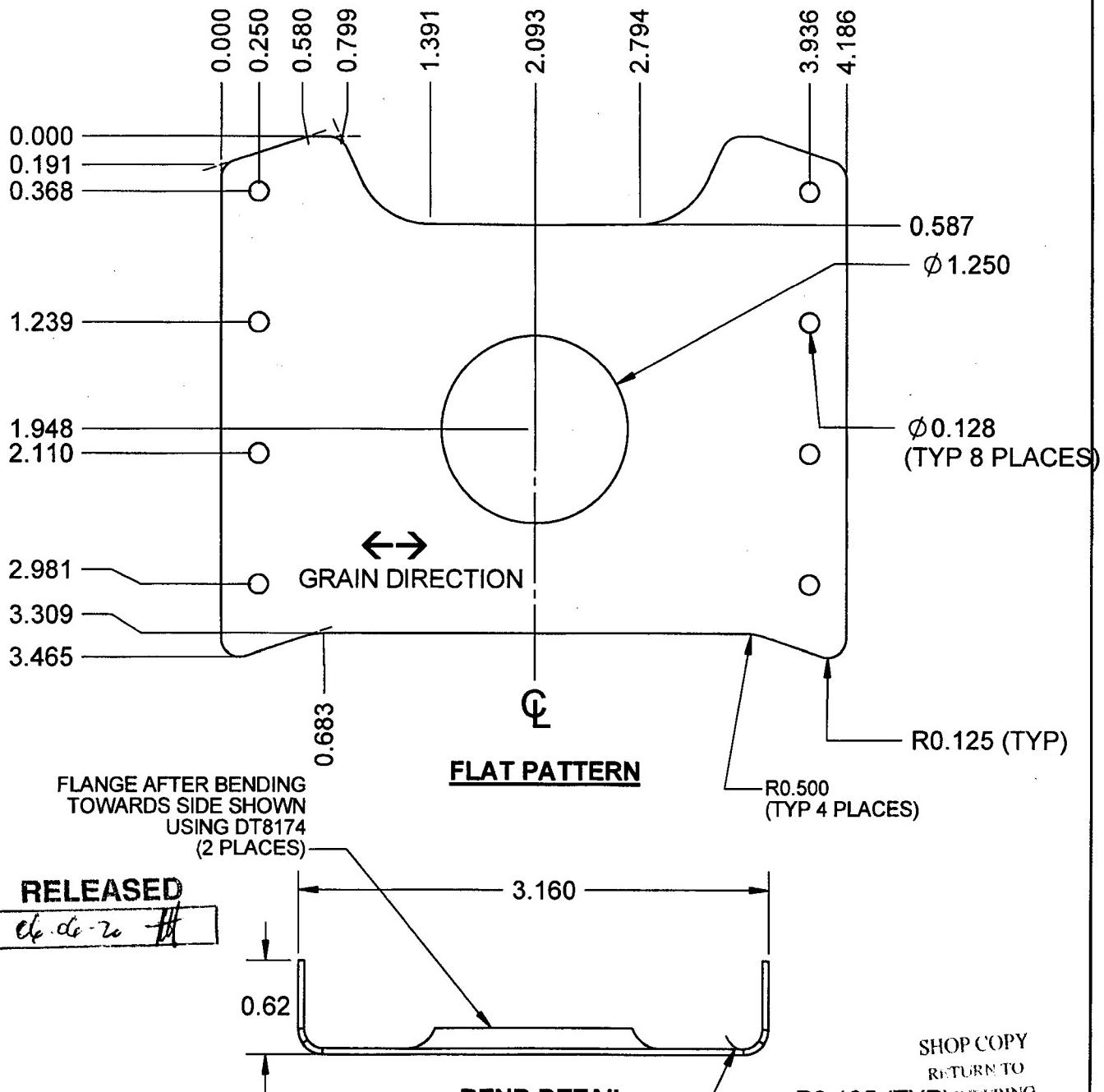
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**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>M</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1	

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER  
NO *45395*

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

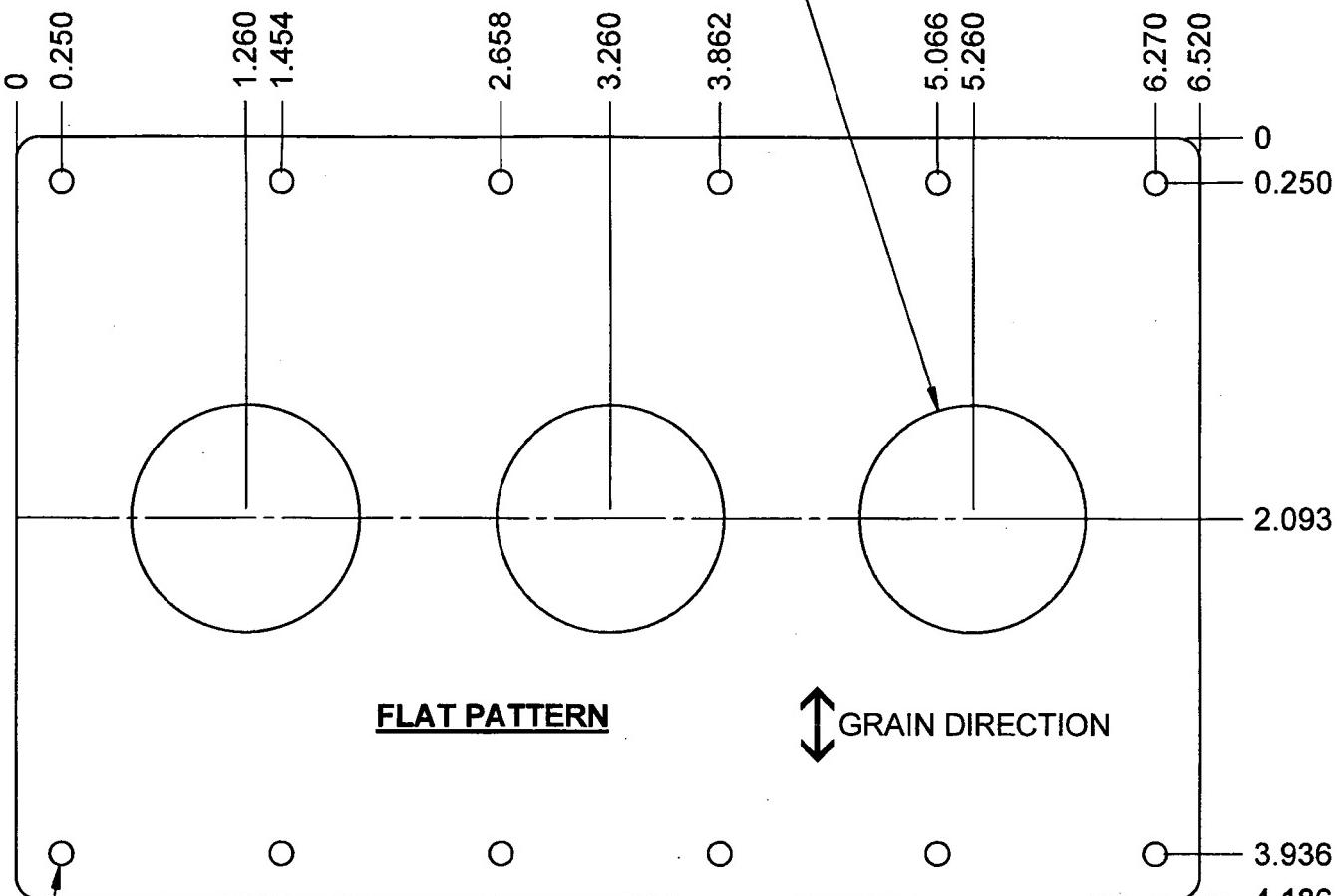
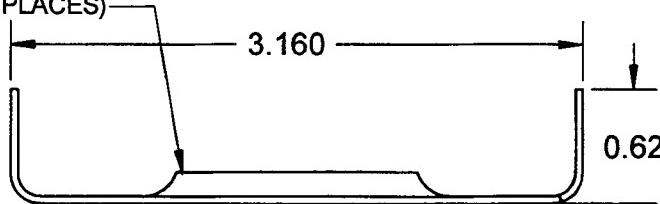
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**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>M</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1	

 $\phi 1.250$  (TYP, 3 PLACES)FLANGE AFTER TOWARDS SIDE  
SHOWN USING DT8174 (3 PLACES) $\phi 0.129$  (TYP, 12 PLACES)**RELEASED***06.06.20 - #***BEND DETAIL**SHOP COPY  
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WITHOUT NOTICE  
WORK IN PROGRESS  
NC *45395***D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

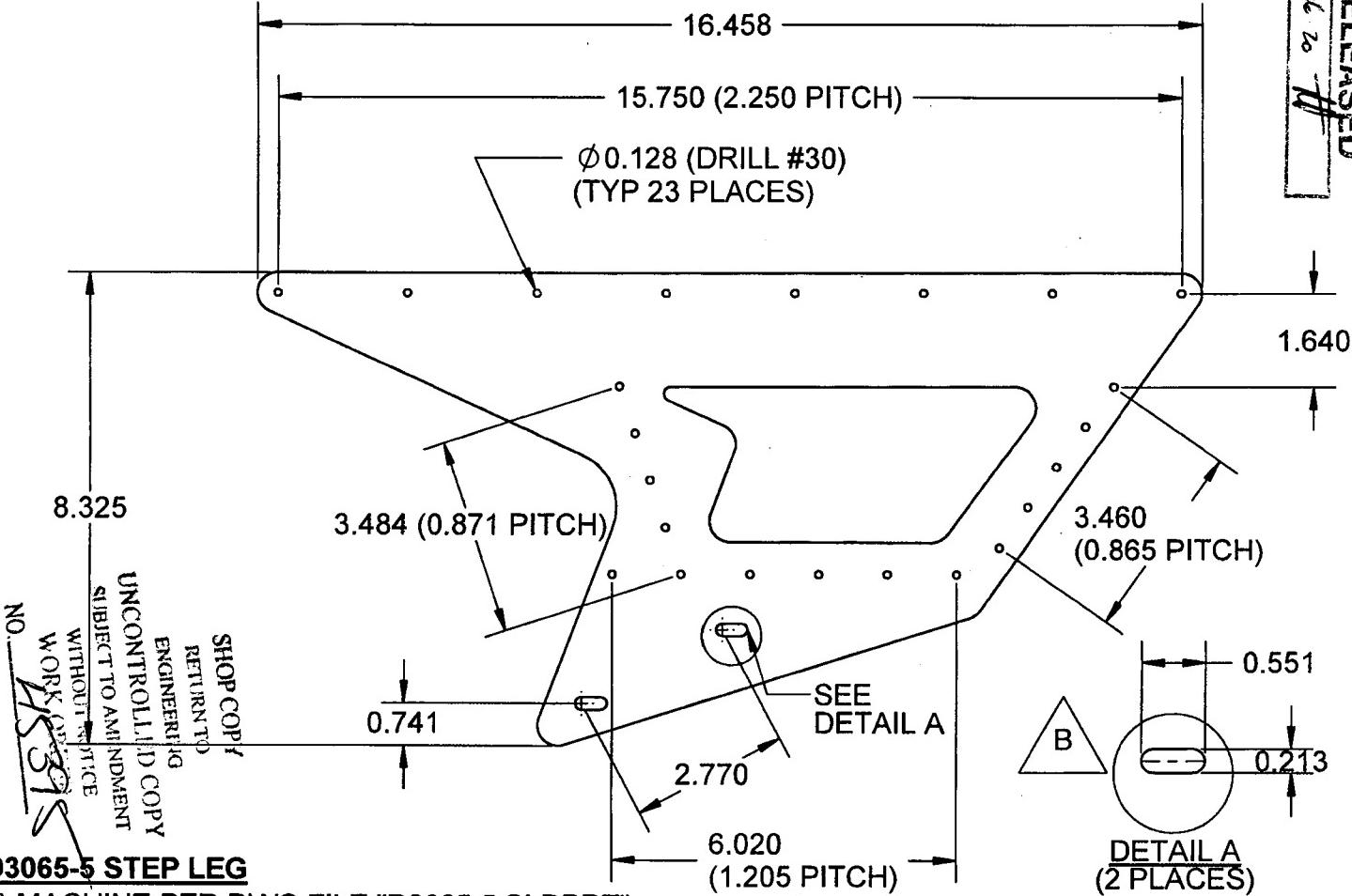
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b>
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
P.H.	J.M.	DRAWING NO. <b>D3065</b>
DATE	06.05.23	TITLE <b>STEP LEG ASSEMBLY</b>

**RELEASED**  
06.06.23**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

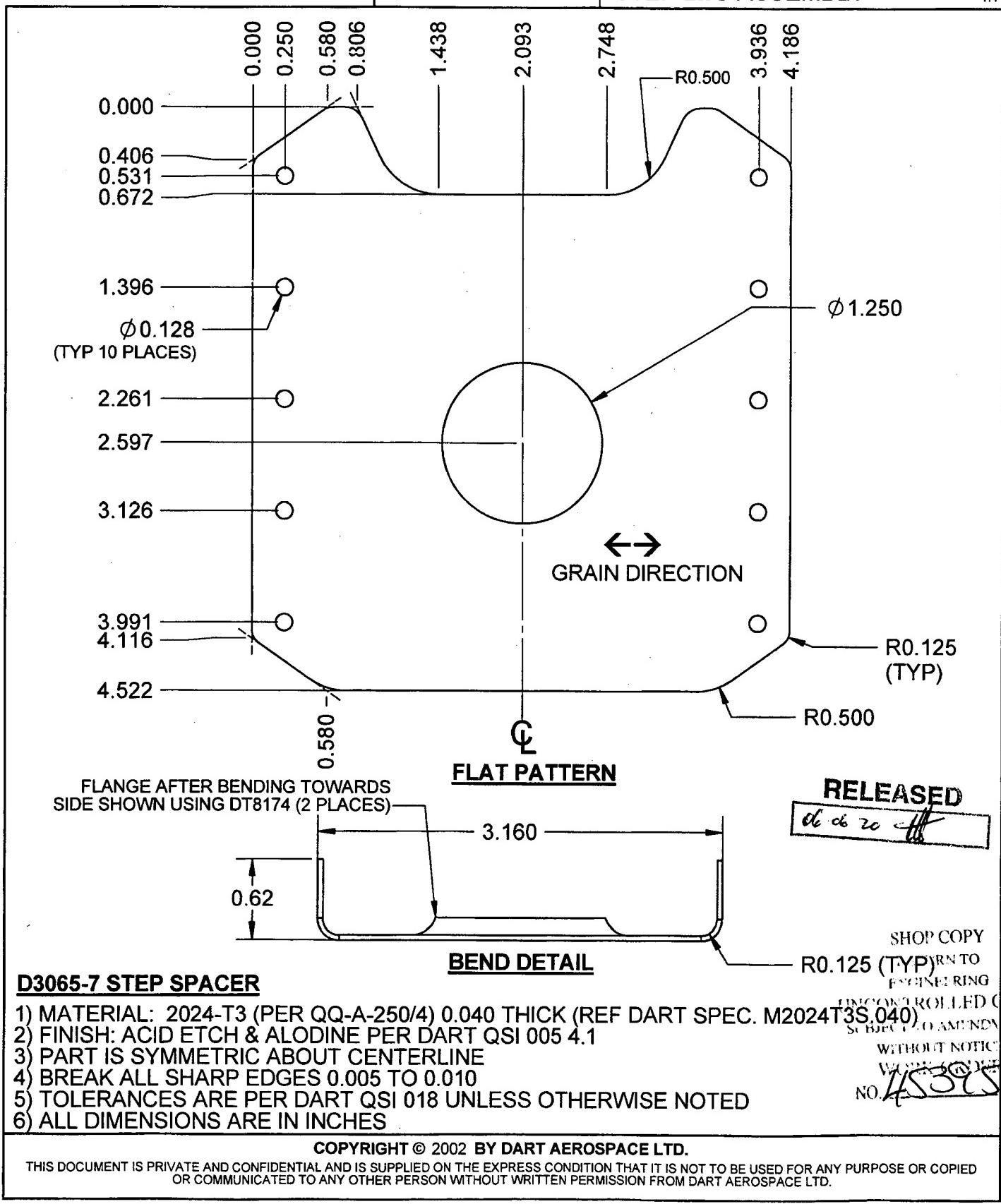
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**DART**

DESIGN <i>IP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>CH</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1	



W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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